



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 180457



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 9/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

ARC's done

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/6/18	9/6/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	10 pcs	9/6/18	9/6/18	0.00	9.91	Large Fab 2		
120	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC9		
130	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC5		
140	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.84	HandFinish1		
150	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC7-2		
180	Large Fab	10 pcs	9/6/18	9/6/18	0.00	9.91	Large Fab 2		
190	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC10		
200	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC5		
210	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.84	HandFinish1		
220	Powdercoat	10 pcs	9/6/18	9/6/18	0.00	2.90	Powdercoat1		
230	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.84	HandFinish3		
240	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC3		
250	Packaging	10 pcs	9/6/18	9/6/18	0.00	0.00	Packaging1-3		
260	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC4		
270	Packaging	10 pcs	9/6/18	9/6/18	0.00	0.00	Packaging3-1		
275	DC	10 pcs	9/6/18	9/6/18	0.00	0.00	DC		
280	QC21-FG	10 Ea	9/6/18	9/6/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M130137 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum

6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 1:45 OVEN TEMPERATURE: 320 FINISH TIME: 2:15

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5070880
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5091443
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5105671
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	

D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	5107308 → 6x	5090186 → 14
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	5057529 → 90	5090186 → 70
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging		
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging		
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging		
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging		
D2618	Bushing	20 Ea (2 ea)	250-Packaging		
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging		
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging		
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging		
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging		
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging		
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging		
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging		
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging		
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	133	0
	D3219-1	20	123	0
	D3272-1	10	25	0
180-Large Fab	D3065-041	10	18	0
	D3066-1	20	178	0
	MS20600-AD4W4	160	3,204	0
250-Packaging	AN3-35A	20	380	0
	AN4-13A	80	2,267	0
	AN5-36A	20	324	0
	D2230-3	40	333	0
	D2618	20	220	0
	D2856-400-720	20	74	0
	D3235-1	20	117	0
	D3278-041	10	42	0
	MS21042L3	20	2,128	0
	MS21042L4	80	3,306	0
	MS21042L5	20	922	0
	NAS1149D0363J	40	1,662	0
	NAS1149D0463J	160	7,409	0
	NAS1149D0563J	40	1,662	0

Part Specifications

Specifications could not be found.

Plex 7/6/18 11:45 AM Dart.lajeunesse.marie

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R E V . B



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Container No: S106604



Part: D350-591-311

Job No: 180457

Serial No/Batch: S106604

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11 Date 11-29-94 FAA STC SH967NE



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004838

D350-591-311
Job Sheet 180457



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 9/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		9/6/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	10 pcs		9/6/18	0.00	9.91	Large Fab 2		
120	QC	10 pcs		9/6/18	0.00	0.00	QC9		
130	QC	10 pcs		9/6/18	0.00	0.00	QC5		
140	HandFinish	10 pcs		9/6/18	0.00	1.84	HandFinish1		
150	QC	10 pcs		9/6/18	0.00	0.00	QC7-2		
180	Large Fab	10 pcs		9/6/18	0.00	9.91	Large Fab 2		
190	QC	10 pcs		9/6/18	0.00	0.00	QC10		
200	QC	10 pcs		9/6/18	0.00	0.00	QC5		
210	HandFinish	10 pcs		9/6/18	0.00	1.84	HandFinish1		
220	Powdercoat	10 pcs		9/6/18	0.00	2.90	Powdercoat1		
230	HandFinish	10 pcs		9/6/18	0.00	1.84	HandFinish3		
240	QC	10 pcs		9/6/18	0.00	0.00	QC3		
250	Packaging	10 pcs		9/6/18	0.00	0.00	Packaging1-3		
260	QC	10 pcs		9/6/18	0.00	0.00	QC4		
270	Packaging	10 pcs		9/6/18	0.00	0.00	Packaging3-1		
275	DC	10 pcs		9/6/18	0.00	0.00	DC		
280	QC21-FG	10 Ea		9/6/18	0.00	0.00	QC21		

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Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	



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Container No: S106604



Heli - Access - Step LH - High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350-591-311

Serial No/Batch: S106604

Revision:

Operation:

Change No:

**Packaging
CHG002**

Mfg Date: 08/29/18
Job No: 180457

D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

5089307
 5089302
 5083019
 5106286
 5089946
 5098273
 5089615
 5106503
 5089340
 5089365
 5058178x19 508354
 5068661
 5089299
 5093772

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	133	0
	D3219-1	20	123	0
	D3272-1	10	25	0
180-Large Fab	D3065-041	10	18	0
	D3066-1	20	178	0
	MS20600-AD4W4	160	3,204	0
250-Packaging	AN3-35A	20	380	0
	AN4-13A	80	2,267	0
	AN5-36A	20	324	0
	D2230-3	40	333	0
	D2618	20	220	0
	D2856-400-720	20	74	0
	D3235-1	20	117	0
	D3278-041	10	42	0
	MS21042L3	20	2,128	0
	MS21042L4	80	3,306	0
	MS21042L5	20	922	0
	NAS1149D0363J	40	1,662	0
	NAS1149D0463J	160	7,409	0
	NAS1149D0563J	40	1,662	0

Part Specifications

Specifications could not be found.



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004838	S099035	AN3-35A	Bolt	s089307	ST348	20
004838	S099032	AN4-13A	Bolt	S089302	OVER003	80
004838	S099026	AN5-36A	Bolt	s083019	ST336	20
004838	S099045	D2618	Bushing	S089996	ST012A	20
004838	S099046	D2856-400-720	Abrasion Strip 4" X 7.20"	S098273	ST418	20
004838	S099047	D3235-1	Mounting Lug	S089615	ST522	20
004838	S099002	MS21042L3	Nut	s089340	ST303	20
004838	S098998	MS21042L4	Nut	s089365	ST303	80
004838	S058178	MS21042L5	Nut		ST303	19
004838	S098987	MS21042L5	Nut	S083541	ST303	1
004838	S098960	NAS1149D0463J	Washer	S089299	ST263	160
004838	S098946	NAS1149D0563J	Washer	S093773	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 8/3/18 9:13 AM Dart.joly.jocelyne

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.



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Material Trace Report

Container No	Part No	Operation	Quantity	Weight	Add Date	Location	Status	Update Date	Active
S106604	D350-591-311	QC21-FG	10	0	8/29/18	FG084	Stock	9/10/18	✓
S041171	MS20600-AD4W4	Receive Ea	0	0	2/11/18	Large Fab 2	Allocated	8/31/18	
S058178	MS21042L5	Receive Ea	0	0	4/4/18	Packaging1-3	Allocated	9/10/18	
S090186	D3066-1	QC21-SA	0	0	7/9/18	Large Fab 2	Allocated	8/31/18	
S098946	NAS1149D0563J	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S098960	NAS1149D0463J	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S098987	MS21042L5	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S098998	MS21042L4	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099002	MS21042L3	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099026	AN5-36A	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099032	AN4-13A	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099035	AN3-35A	Receive Ea	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099045	D2618	QC21-SA	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099046	D2856-400-720	QC21-SA	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S099047	D3235-1	QC21-SA	0	0	8/3/18	Packaging1-3	Allocated	9/10/18	
S105671	D3272-1	QC21-SA	0	0	8/28/18	Start Up Large Fab-4	Allocated	8/29/18	
S106060	D3065-041	QC21-SA	0	0	8/28/18	Large Fab 2	Allocated	8/31/18	
S106601	D3067-1	QC21-SA	0	0	8/29/18	Start Up Large Fab-4	Allocated	8/29/18	
S106603	D3219-1	QC21-SA	0	0	8/29/18	Start Up Large Fab-4	Allocated	8/29/18	
S107308	D3066-1	QC21-SA	0	0	8/31/18	Large Fab 2	Allocated	8/31/18	
S107310	MS20600-AD4W4	Receive Ea	0	0	8/31/18	Large Fab 2	Allocated	8/31/18	
S108670	D2230-3	QC21-SA	0	0	9/10/18	Packaging1-3	Allocated	9/10/18	
S108671	D3278-041	QC21-SA	0	0	9/10/18	Packaging1-3	Allocated	9/10/18	
S108672	NAS1149D0363J	Receive Ea	0	0	9/10/18	Packaging1-3	Allocated	9/10/18	
23 Containers			.00	.00					
23 Containers Total			.00	.00					

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

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